



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-121
Job Sheet 177903



Part No: D350-591-121

Job Qty: 5 ea 6 Cpl

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/22/18

Job Tracking No:

Due Date: 5/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	5 Ea	5/31/18		0.00	0.00	Start Up Large Fab-4		Dr 2018-05-23
110	Large Fab	5 pcs	5/31/18		0.00	3.40	Large Fab 8		Dr 2018-05-23
120	CNC Bend Skid tubes	5 pcs	5/31/18		0.38	1.46	CNC Bend Skid tube		MCAL
122	QC	5 pcs	5/31/18		0.00	0.00	QC5		CPL
140	Large Fab	5 pcs	5/31/18		0.00	3.40	Large Fab 2		CPL
150	QC	5 pcs	5/31/18		0.00	0.00	QC9		Dr 12-06-20
160	QC	5 pcs	5/31/18		0.00	0.00	QC5		Dr 13-06-20
170	HandFinish	5 pcs	5/31/18		0.00	0.93	HandFinish1		BEB 18-06-26
180	QC	5 pcs	5/31/18		0.00	0.00	QC7-2		CPL
190	Large Fab	5 pcs	5/31/18		0.00	3.40	Large Fab 2		CPL
220	QC	5 pcs	5/31/18		0.00	0.00	QC10		Dr 18-06-27
230	QC	5 pcs	5/31/18		0.00	0.00	QC5		Dr 18-06-27
240	HandFinish	5 pcs	5/31/18		0.00	0.93	HandFinish1		CPL
250	Powdercoat	5 pcs	5/31/18		0.00	0.81	Powdercoat1		Dr 18-7-4
260	HandFinish	5 pcs	5/31/18		0.00	0.93	HandFinish3		BEB 18-07-05
270	QC	5 pcs	5/31/18		0.00	0.00	QC3		38
280	Packaging	5 pcs	5/31/18		0.00	0.00	Packaging1-3		Dr JUL 10 2018
290	QC	5 pcs	5/31/18		0.00	0.00	QC4		Dr
300	Packaging	5 pcs	5/31/18		0.00	0.00	Packaging3-1		Dr
305	DC	5 pcs	5/31/18		0.00	0.00	DC		Dr
310	QC21-FG	5 Ea	5/31/18		0.00	0.00	QC21		Dr JUL 12 2018

Part Op 110 - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 2- Drill holes as per dwg using DT8230.

Descriptions: 120 - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. Use DT8033 jig to make sure bend is good and fits the jig.

140 - 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod 413156 3-Do not Grind Flush

190 - 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod 3-Grind and plate flush.

250 - START TIME: 200 OVEN TEMPERATURE: 320° FINISH TIME: 230

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

305 - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

Wing Walk 5080995

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2.5000 Ea (.5 ea)	90-Start up Operation	164533
D2850-1	End Bracket	5 Ea (1 ea)	140-Large Fab	
D2582	Hi-Skid Step Leg Assembly	5 Ea (1 ea)	190-Large Fab	5082562 5072948
D2673-34	End Plate	5 Ea (1 ea)	190-Large Fab	5078838
MS20600-AD4W3	Cherry Rivet	80 Ea (16 ea)	190-Large Fab	5058156 3062619 507600
AN3-37A	Bolt	10 Ea (2 ea)	280-Packaging	
AN4-13A	Bolt	5 Ea (1 ea)	280-Packaging	
AN4-16A	Bolt	10 Ea (2 ea)	280-Packaging	
D2230-1	Mounting Lug	5 Ea (1 ea)	280-Packaging	
D2230-3	Mounting Lug	5 Ea (1 ea)	280-Packaging	
D2732-030	Rubber Cushion - 3"	10 Ea (2 ea)	280-Packaging	
MS21042L3	Nut	10 Ea (2 ea)	280-Packaging	
MS21042L4	Nut	15 Ea (3 ea)	280-Packaging	
NAS1149D0363J	Washer	20 Ea (4 ea)	280-Packaging	
NAS1149D0463J	Washer	30 Ea (6 ea)	280-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	3	67	0
140-Large Fab	D2850-1	5	6	0
190-Large Fab	D2582	5	13	0
	D2673-34	5	32	0
	MS20600-AD4W3	80	379	0
280-Packaging	AN3-37A	10	94	0
	AN4-13A	5	1,581	0
	AN4-16A	10	287	0
	D2230-1	5	212	0
	D2230-3	5	111	0
	D2732-030	10	207	0
	MS21042L3	10	1,626	0
	MS21042L4	15	2,869	0
	NAS1149D0363J	20	2,985	0
	NAS1149D0463J	30	6,241	0

Part Specifications				
Specifications could not be found.				



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S073663



Part: D350-591-121

Job No: 177903

Serial No/Batch: S073663

Revision:

Inspector:

Date: 05/23/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004295	S090292	AN3-37A	Bolt	s057513	ST347	12
004295	S090293	AN4-13A	Bolt	s067892	ST344	6
004295	S090294	AN4-16A	Bolt	s082909	ST343	12
004295	S090307	D2230-1	Mounting Lug	S080387	ST521	6
004295	S090309	D2230-3	Mounting Lug	S085080	ST521	6
004295	S090295	D2732-030	Rubber Cushion - 3"	S083726	ST410	12
004295	S090296	MS21042L3	Nut	S078167	ST303	12
004295	S090297	MS21042L4	Nut	S062378	ST303	18
004295	S090298	NAS1149D0363J	Washer	S015269	ST263	24
004295	S090299	NAS1149D0463J	Washer	S062379	ST263	36

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 7/10/18 8:32 AM dart.quirion.sonia

Change Record

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Part Number: D350-591-121

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH

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